

Work Order ID 135464

Wednesday, August 12, 2015 4:29:43 PM

135464

Page 1

Item ID: D350-567-141

Accept

Revision ID:

N900040100

Setup Start

NS1

Item Name: Floor Window Close Out

Stop ***NS2***

Start Date: 7/31/15 Start Qty: 2.00

Required Date: 8/12/15 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: AUG 14 2015 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Document Control	0.00							
DC	DOCUMENT CONTROL								
Doc.Control -USB or Paperwork	Memo	0.00							
	Photocopy bluefile & type labels per PPP D350-567-141 CHG004								
									DAS 02 9-89 OCT 13 2015
110	Pick Kit	0.00							
110	Packaging								
Packaging	Memo	0.00							
									② J.A. AUG 17 2015
120	QC4- 100% Inspect kits for completeness	0.00							
120	QC								
Quality Control	Memo	0.00							
									DAS 02 9-89 OCT 13 2015

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135464

Page 2

Item ID: D350-567-141

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Floor Window Close Out

Stop ***NS2***Start Date: 7/31/15 Start Qty: 2.00 ***2***Required Date: 8/12/15 Req'd Qty: 2.00 ***2***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							DAS 02 9-89
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-141 Location:FG033								OCT 13 2015
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

OCT 13 2015

~~6107-61-130~~

OCT 13 2015

Picklist Print

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Work Order ID: 135464

135464

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 7/31/15

Required Date: 8/12/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM
 12.01.23 AS PER ECN12-511 DD VERF:EC
 AS PER ECN12-537 DD VERF:EC
 DSI9590 REV:E DD VERF:JLM
 VERIFIED BY:DD
 IPP REV:B
 IPP REV:C 12.03.05
 IPP REV:D 13.04.01 AS PER
 IPP REV:E AS PER DSI9590 REV F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4434-047		Manufactured	No				Each	6.0000	1	2			
D4434-047	DAS 02 9-89								**	JA			
Cover Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST619				6					
				29467				2					
				130226				4					
D3802-1		Manufactured	No			110	f	131.7500	2	4			
D3802-1-024	DAS 02 9-89								**	JA			
Windows Seal (\$ Per Foot)													
Qty 1 @ 24" per DWG, per kit	DAS 38 9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST421				131.75					
				134091				131.75					
D4434-041		Manufactured	No			110	Each	3.0000	1	2			
D4434-041	DAS 02 9-89								**	JA			
Fwd Bracket Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST623				3					
				127902				2					
				134490				1					

AUG 17 2015

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Page 2

Work Order ID: 135464

135464

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 7/31/15

Required Date: 8/12/15

Start Qty: 2.00

Required Qty: 2.00

D4435-045

Manufactured No

110 Each 9.0000 1 2

D4435-045

T/R Bellcrank Cover Assembly

DAS
02
9-89

**

JA.

DAS
6
9-89

Location

Loc Qty

Loc Code

ST620

9

127215

9

2

D4435-9

Manufactured No

110 Each 2.0000 2 4

D4435-9

Bracket

DAS
02
9-89

**

JA

Shub

DAS
6
9-89

Location

Loc Qty

Loc Code

ST107

2

134469

2

2

D4436-041

Manufactured No

110 Each 0.0000 1 2

D4436-041

Aft Bracket Assembly

DAS
02
9-89

**

J

136525

DAS
6
9-89

D4441-1

Manufactured No

110 f 543.3750 2 4

D4441-1 -240

Rubber Seal

DAS
02
9-89

**

JA

AUG 17 2015

DAS
6
9-89

Location

Loc Qty

Loc Code

ST407

355.875

120932

355.875

ST422

187.5

120932

187.5

4

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Shop Packet Print

Page 2

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Page 3

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Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 7/31/15

Required Date: 8/12/15

Start Qty: 2.00

Required Qty: 2.00

AN3-3A

Purchased

No

110

Each

396.0000

7

14

***AN3-3A**

Bolt

DAS
02
9-89

JA

Location

Loc Qty

Loc Code

ST338a

200

m131624

200

ST350

196

m132317

196

14

AN525-10R6

Purchased

No

110

Each

46.0000

2

4

***AN525-10R6**

Screw

DAS
02
9-89

JA

Location

Loc Qty

Loc Code

ST329

46

m131420

46

4

AN525-832R7

Purchased

No

110

Each

86.0000

2

4

***AN525-832R7**

Screw

DAS
02
9-89

JA

AUG 17 2015

Location

Loc Qty

Loc Code

GA

24

m131957

24

ST328

62

m131957

62

m131957

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Work Order ID: 135464

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Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 7/31/15

Required Date: 8/12/15

Start Qty: 2.00

Required Qty: 2.00

MS21042L06

Purchased

No

110

Each

210.0000

7

14

MS21042I 06

Nut

DAS
02
9-89

**

JA

Location

Loc Qty

Loc Code

ST304

101

m131294

1

m132803

100

ST305

109

m129499

3

m131317

106

14

DAS
02
9-89

MS21042L08

Purchased

No

110

Each

1,162.000

2

4

MS21042I 08

Nut

DAS
02
9-89

**

JA

AUG 17 2015

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST260a

243

m131697

243

4

ST304

818

123900

16

m128401

102

m128429

3

m131317

197

m132930

500

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Work Order ID: 135464

135464

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 7/31/15

Required Date: 8/12/15

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

110

Each

1,578,000

5

10

MS21042L3

**

JA

Nut

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

393

M130922

393

GA

270

M131317

270

ST305

915

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

333

M132930

500

10

MS21059L3

Purchased

No

110

Each

81.0000

2

4

MS21059L3

**

JA

AUG 17 2015

Nut Plate

DAS
02
9-89

Location

Loc Qty

Loc Code

CA

16

M129682

16

GA

32

113749

1

M132677

31

ST303

33

M131616

33

4

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135464

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 7/31/15

Required Date: 8/12/15

Start Qty: 2.00

Required Qty: 2.00

MS35206-229

Purchased No

110

Each

99.0000

7

14

MS35206-229

Screw

DAS

02

9-89

**

JA

DAS

9-89

Location

Loc Qty

Loc Code

ST277

99

M132763

99

14

NAS1149F0332P

Purchased

No

110

Each

1,516.000

12

24

NAS1149F0332P

Washer

DAS

02

9-89

**

JA

DAS

9-89

Location

Loc Qty

Loc Code

GA

222

122063

222

ST260a

1201

m128401

6

m131026

80

M131697

1115

24

st268

93

123900

7

m130388

86

NAS1149FN616P

Purchased

No

110

Each

192.0000

14

28

NAS1149FN616P

WASHER

DAS

02

9-89

**

JA

AUG 17 2015

DAS

9-89

Location

Loc Qty

Loc Code

ST267

190

M132763

190

28

st268

2

M131026

2

Picklist Print

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Work Order ID: 135464

135464

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 7/31/15

Required Date: 8/12/15

Start Qty: 2.00

Required Qty: 2.00

NAS1149FN816P

Purchased

No

110

Each

794.0000

2

4

NAS1149FN816P

DAS

02

WASHER

9-89

JA

AUG 17 2015

D

8

9-89

Location

Loc Qty

Loc Code

st268

794

117316

794

4

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. E OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-18

FAA STC: SH989NE

FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141/-143/-145 Close-out Kits, which are intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141/-143/-145 Floor Window Close-out Kits provide a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1. The -143 Kit is identical to the -141 Kit with the exception of the D4971-041 T/R Bellcrank Cover Assy which replaces the D4435-045 T/R Bellcrank Cover Assy on aircraft fitted with energy attenuating seats. The -145 Kit is similar to the -143 Kit but is only kit compatible with the AS350 B3e aircraft.

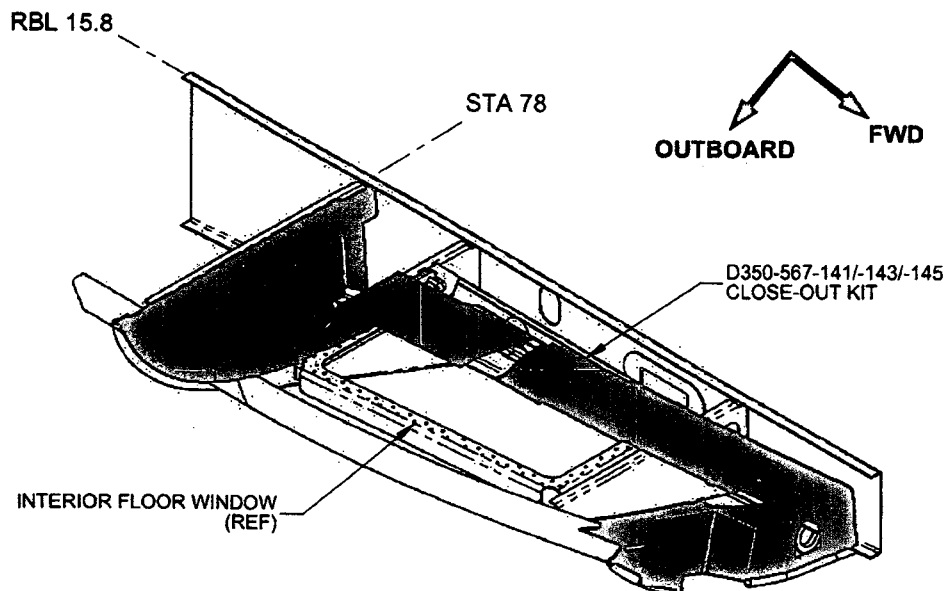


Figure 1. Floor Window Close-out Kit Installation

F	ADDED D4434-047 TO -141 KIT SEE PAR14-372.	AJS	15.01.12
E	ADD -143/-145 KITS	RF	14.03.20
E	CLARIFY FIGURES 3-12	VS	13.09.11
C	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P	RF	12.03.13
B	MS35206-229 WAS AN525-632R6; NAS1149FN816P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 19
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	FLOOR WINDOW CLOSE-OUT KIT	NTS
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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145 Floor Window Close-out Kit	3.9 lb 1.77 kg	17.9 in 0.45 m	69.8 in-lb 0.80 m-kg	65.5 in 1.66 m	255.5 in-lb 2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
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BRANCH
DAO # 01-O-01

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BY:

D. SHEPHERD (DE # 02)

DATE: 15.01.12
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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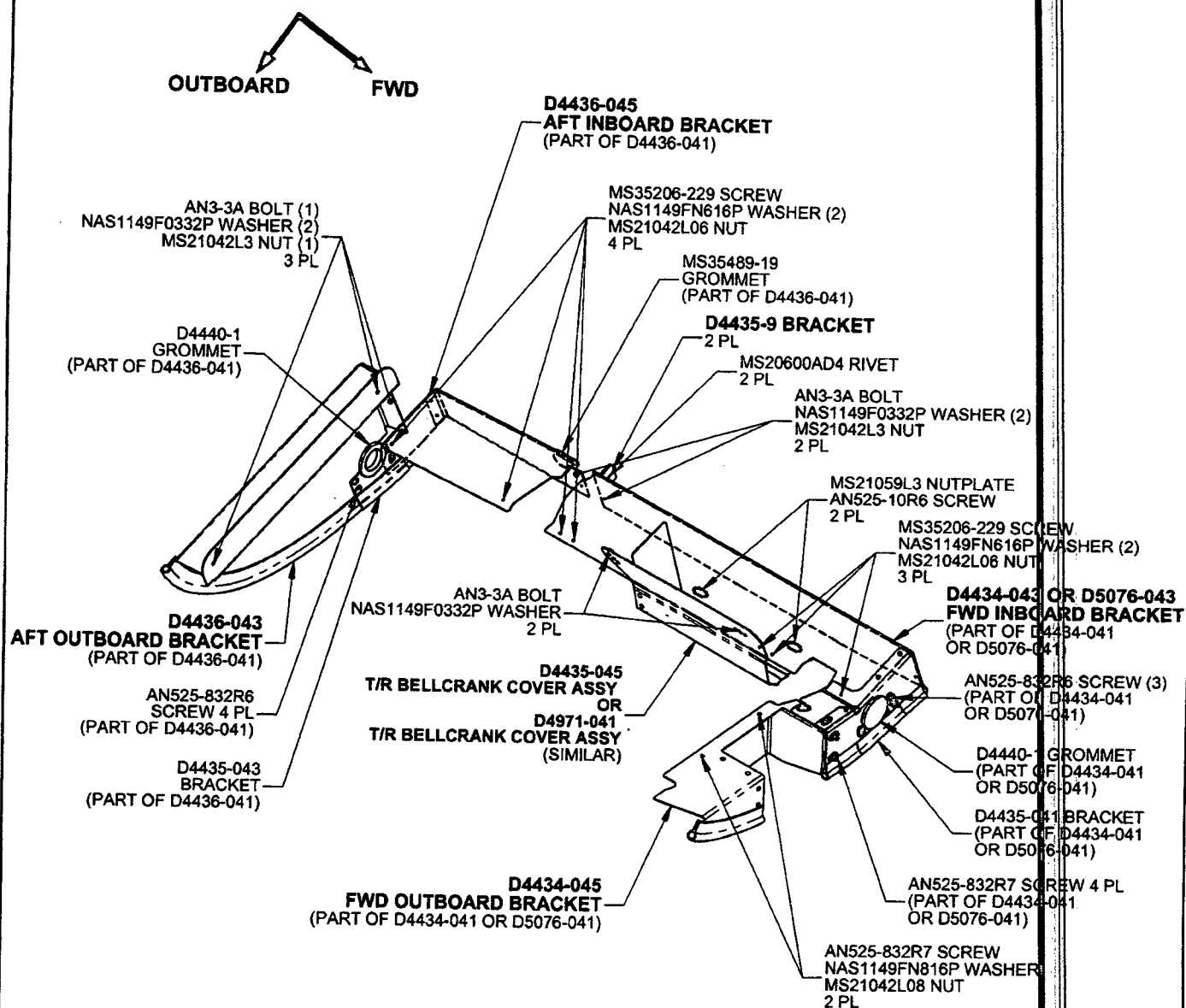


Figure 2. Floor Window Close-out Kit Installation

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BRANCH
DAO # 01-O-01

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DATE: 15.01.12
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4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or cleco clamps. Before drilling holes:

- a) Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
- b) Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.

4.2 Temporarily install D4434-043/D5076-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 /D5076-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.

F 4.3 For -141 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.4 For -143 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4971-041 T/R Bellcrank cover as shown in Figure 13b. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.5 For -145 installations, if aircraft is equipped with Collective Circuit Breaker Board box, use D5076-043 Fwd Inboard Bracket as shown in Figure 13c. Install D4971-041 T/R Bellcrank cover as shown in Figure 13c. Note: Confirm the D5076-3 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.6 Drill out rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x $\varnothing 0.144$ holes to D4434-043/D5076-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x $\varnothing 0.144$ holes for D4434-043/D5076-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043/D5076-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.

4.7 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.

4.8 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x $\varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.

4.9 Drill a pilot hole from D4435-9 Bracket to the D4434-043/D5076-043 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.

4.10 Transfer drill 2 x $\varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x $\varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 screws, NAS1149FN816P washer and MS21042L08 nuts.

4.11 FOR D350-567-141 KIT

a) Align D4435-045 T/R Bellcrank Cover Assy with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12a.

b) Transfer drill 2 x $\varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover Assy to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12a and Figure 13a. Install D4435-045 T/R Bellcrank Cover Assy using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12a and Figure 13a.

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APPROVED

BY: 
D. SHEPHERD (DE # 02)

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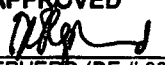
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MFG. APPR.	N/A	DSI 9590	SHEET 4 OF 19
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4.12 FOR D350-567-143/-145 KIT

- a) Remove the D4972-041 Side Plate Assy from the D4971-041 T/R Bellcrank Cover Assy and retain fasteners.
 - b) Align D4971-1 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12b.
 - c) Bond D4730-020-030 Velcro to back of D4971-1 T/R Bellcrank Cover as shown in Figure 12b using CE 200 adhesive.
 - d) Transfer drill 2 x $\varnothing 0.098$ holes from D4971-1 Cover Plate to D4434-043/D5076-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043/D5076-043 Fwd Inboard Bracket as shown in Figure 13b/13c. Install D4971-1 Cover Plate using AN525-10R6 screws and D4730-020-030 Velcro per Figure 12b and Figure 13b/13c.
 - e) Re-install the D4972-041 Side Plate Assy using the retained fasteners.
- 4.13 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
 - 4.14 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
 - 4.15 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
 - 4.16 Ensure there is a gap between the components of the D350-567-141/-143/-145 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-141/-143/-145 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.

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BRANCH
DAO # 01-O-01

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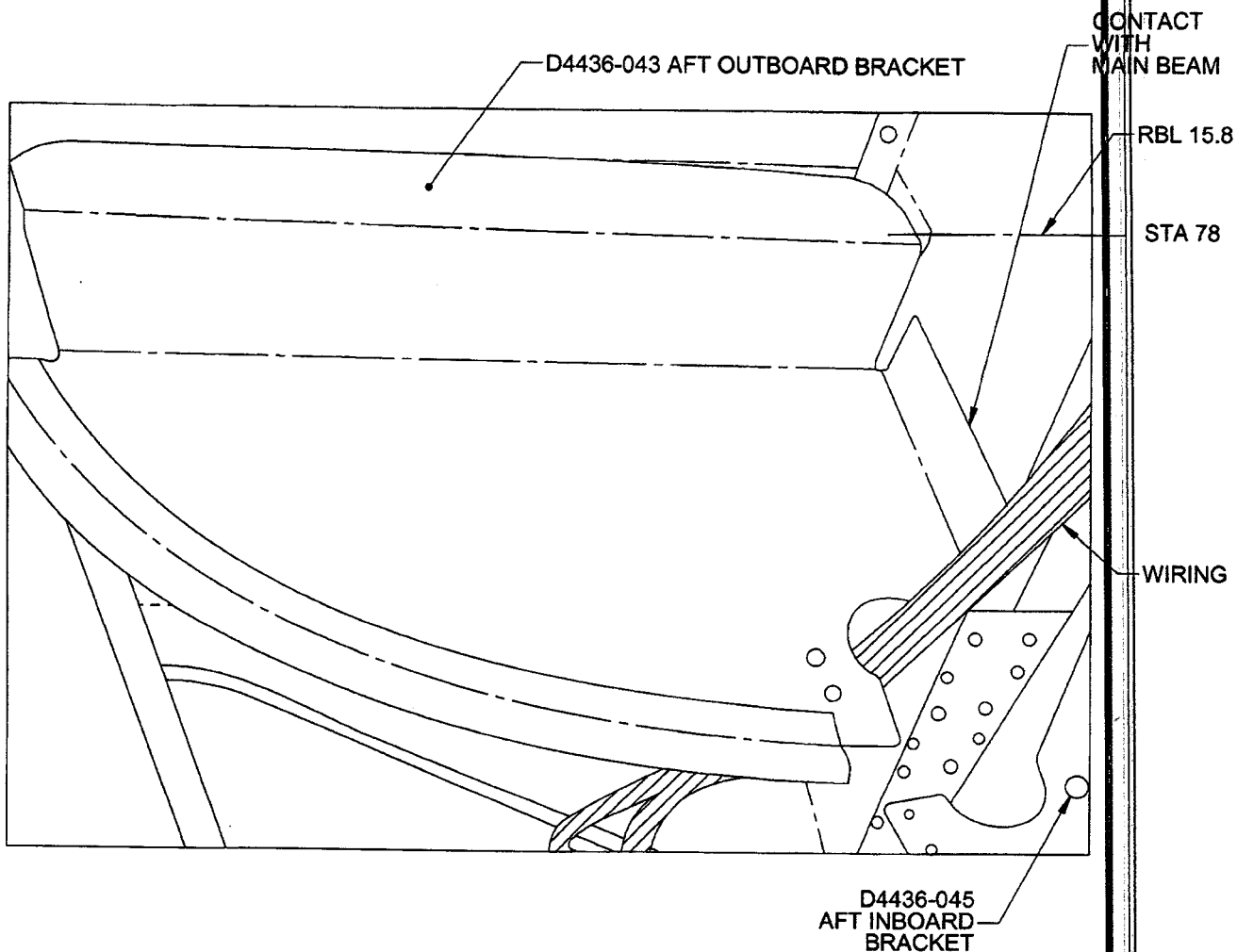


Figure 3. D4436-043 Aft Outboard Bracket Installation

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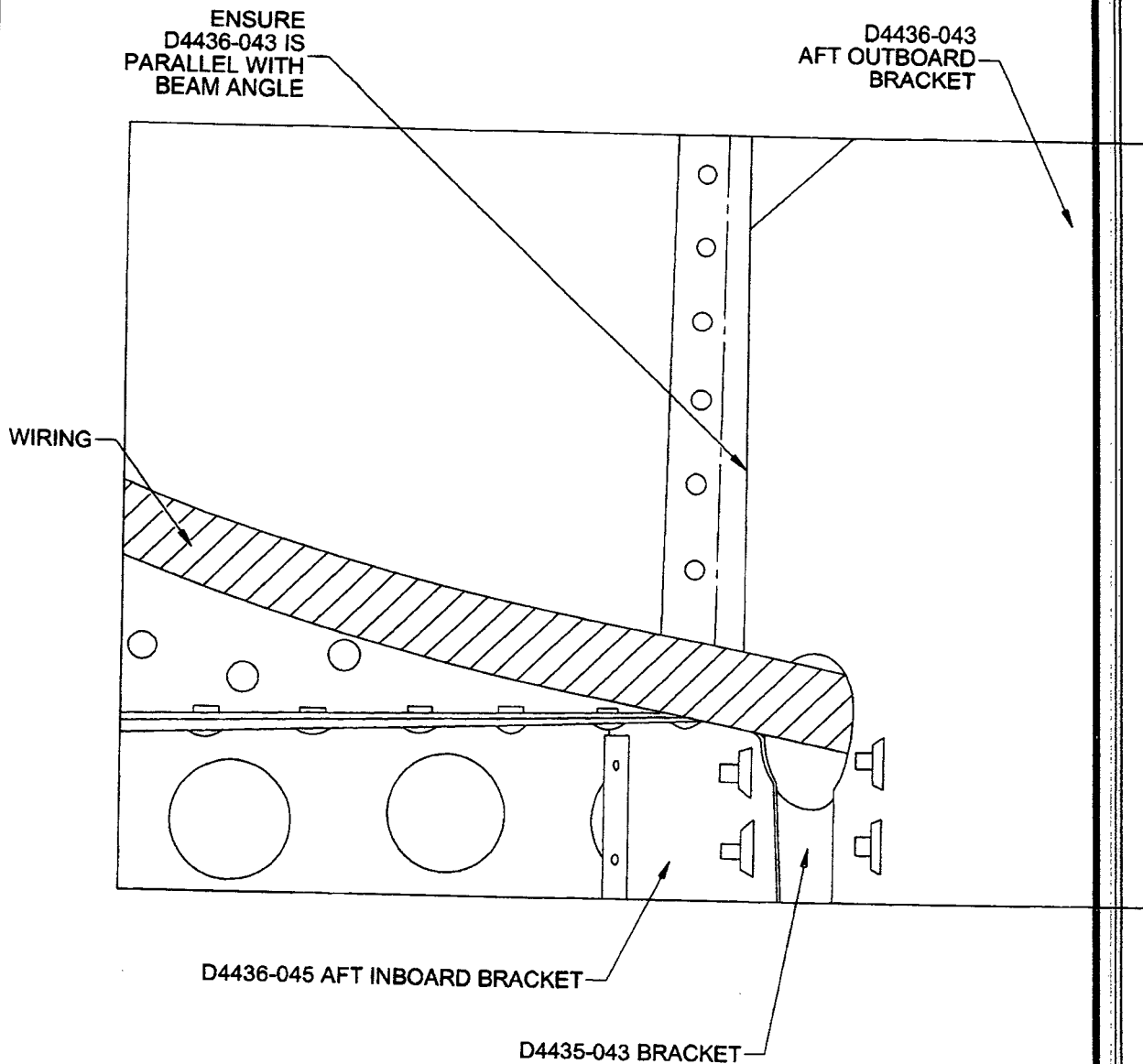


Figure 4. D4436-043 & D4435-043 Brackets Installation

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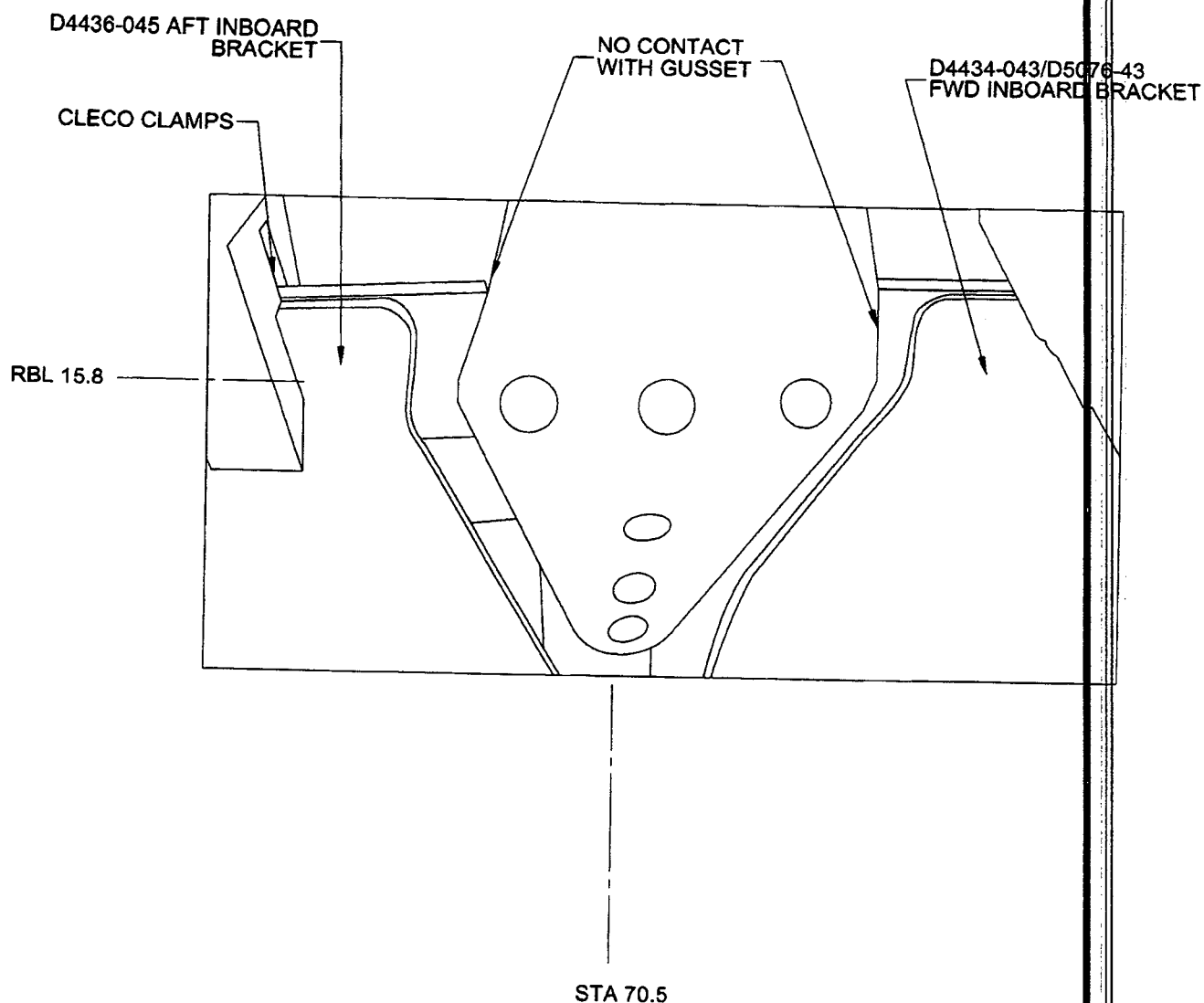


Figure 5. D4436-045 & D4434-043/D5076-043 Brackets Installation

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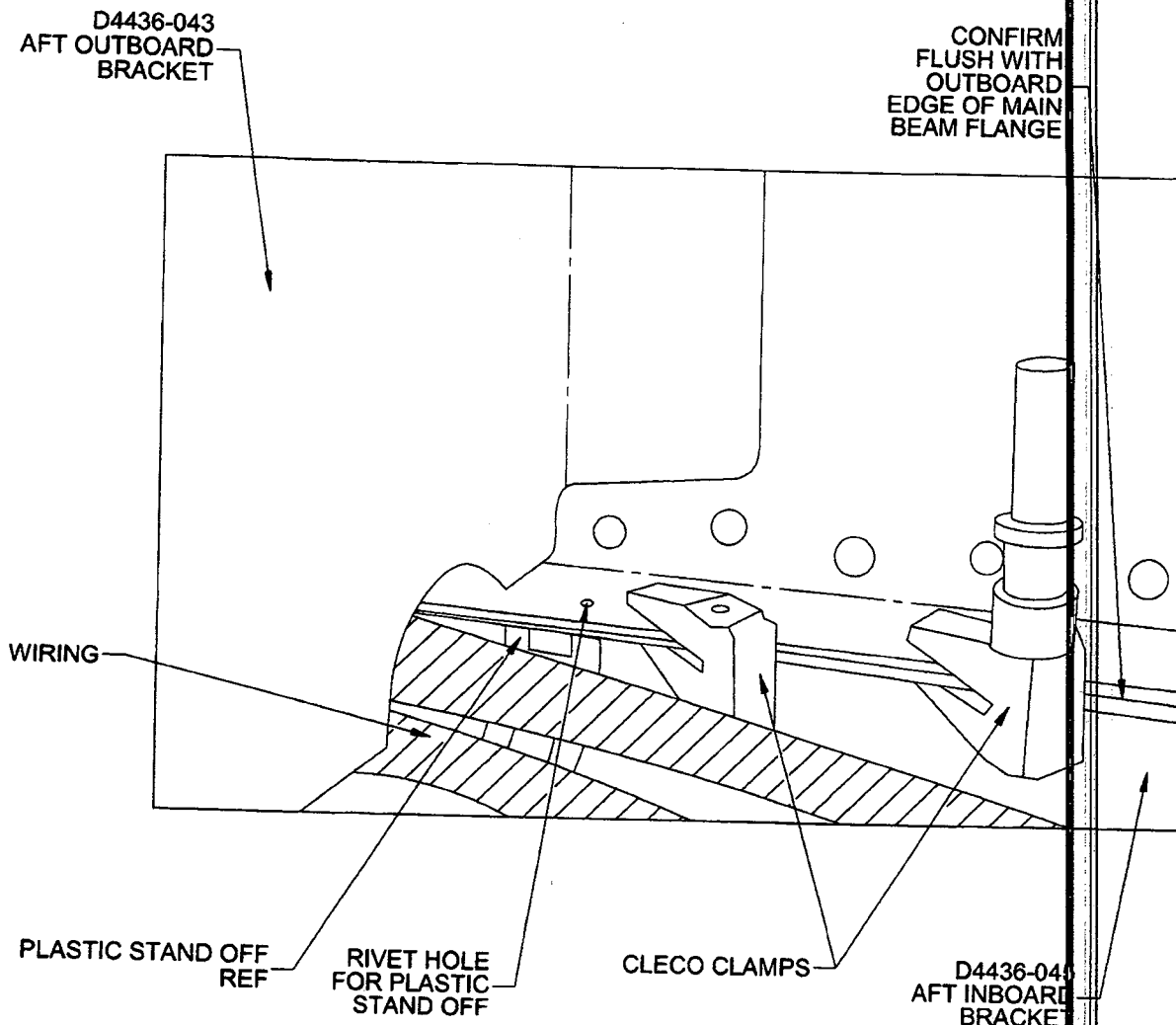


Figure 6. D4436-043 & D4436-045 Brackets Installation

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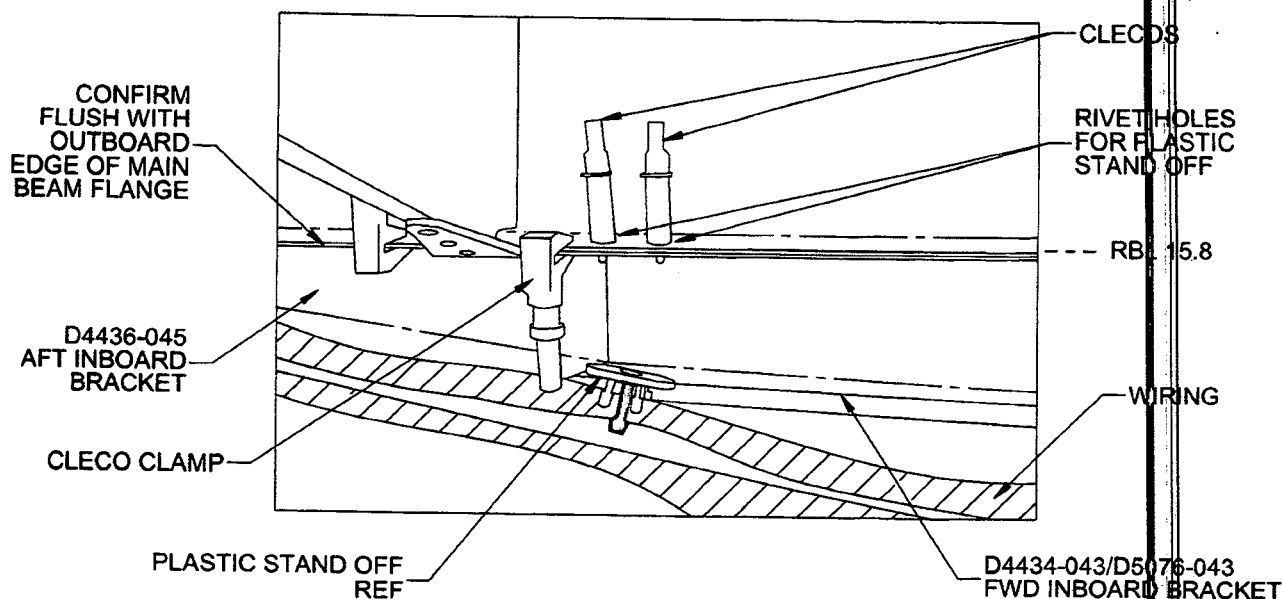


Figure 7. D4434-043/D5076-043 & D4436-045 Brackets Installation

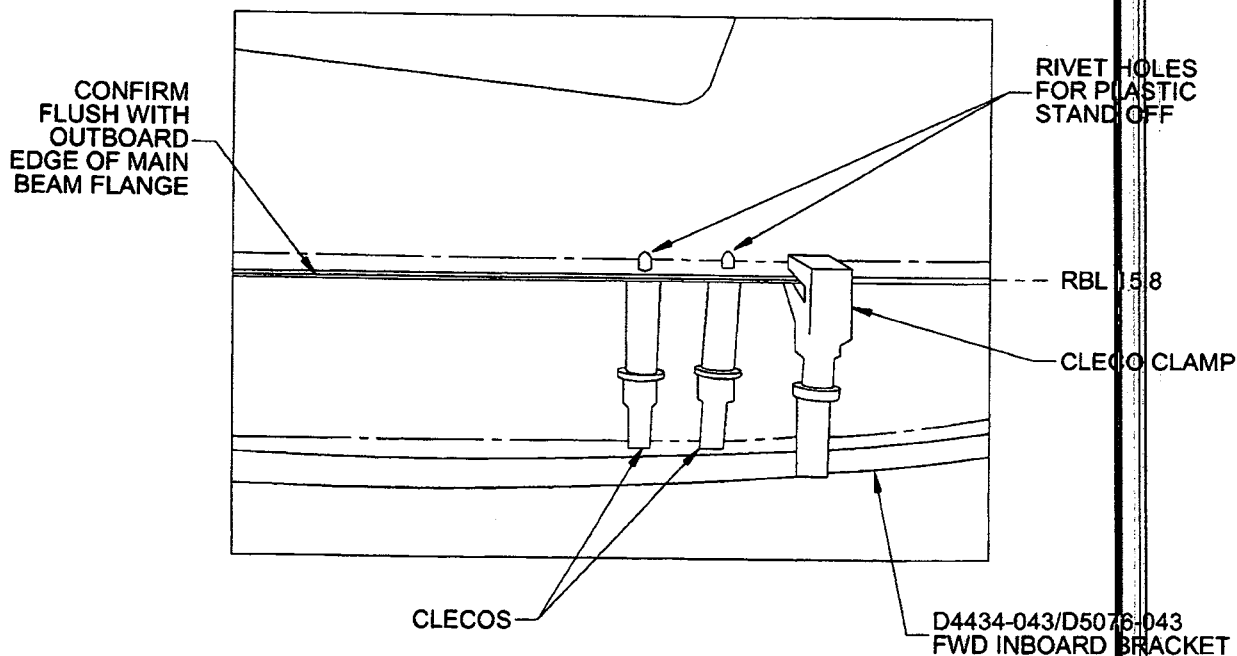


Figure 8. D4434-043/D5076-043 Fwd Inboard Bracket Installation

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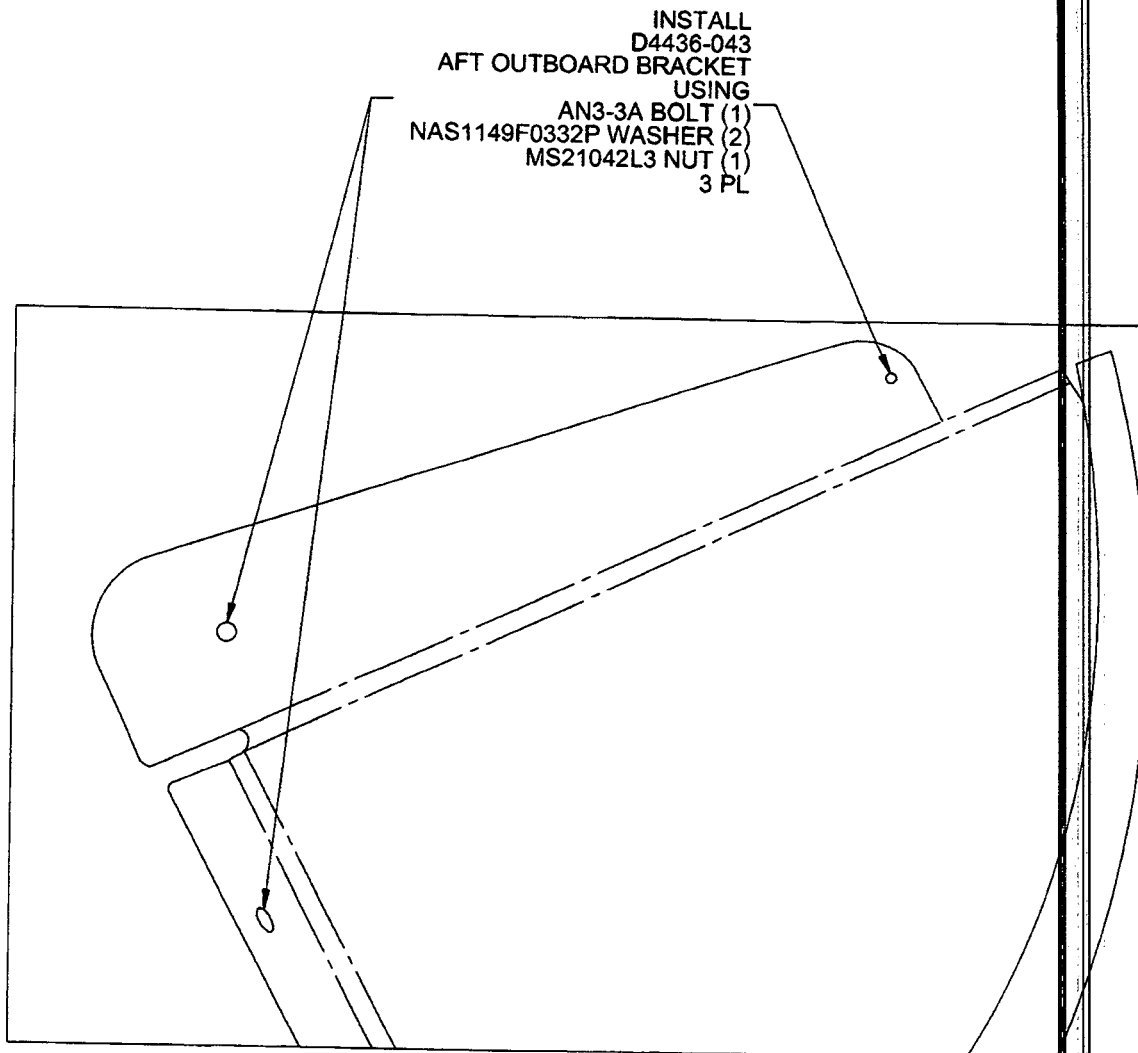


Figure 9. D4436-043 Aft Outboard Bracket Installation

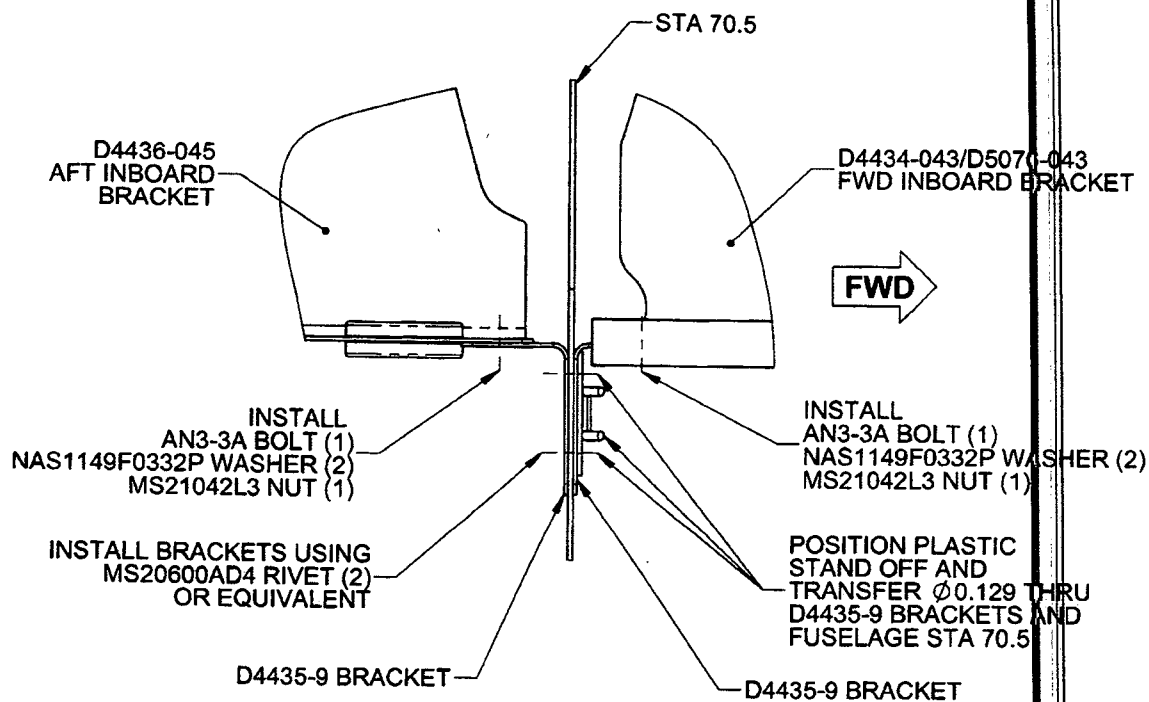
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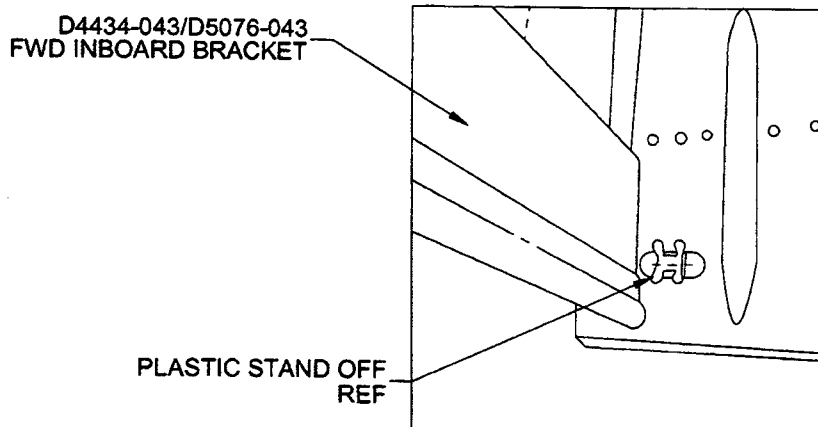


Figure 10. D4434-043/D5076-043 and D4435-9 Brackets Installation

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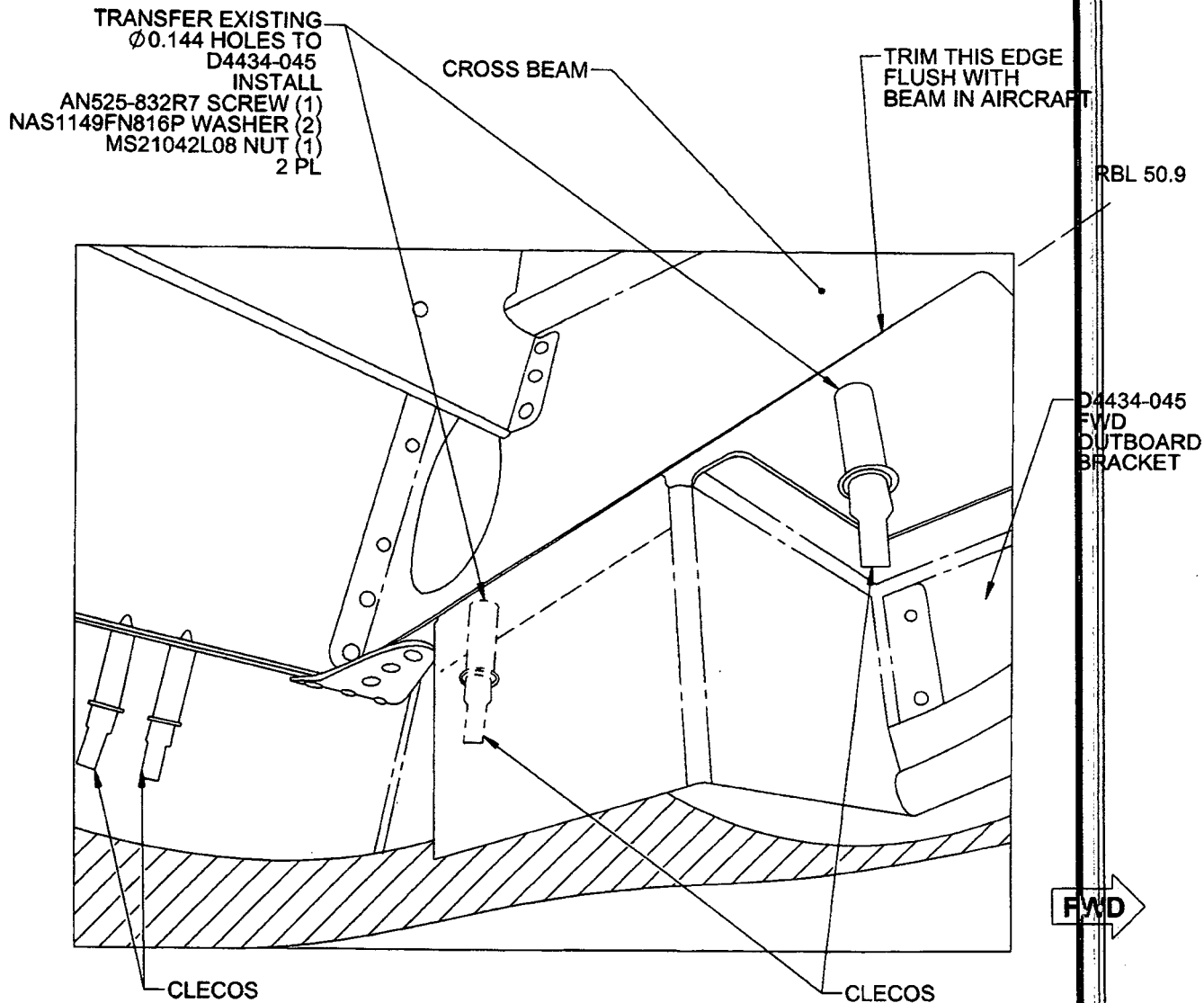


Figure 11. D4434-045 Bracket Installation

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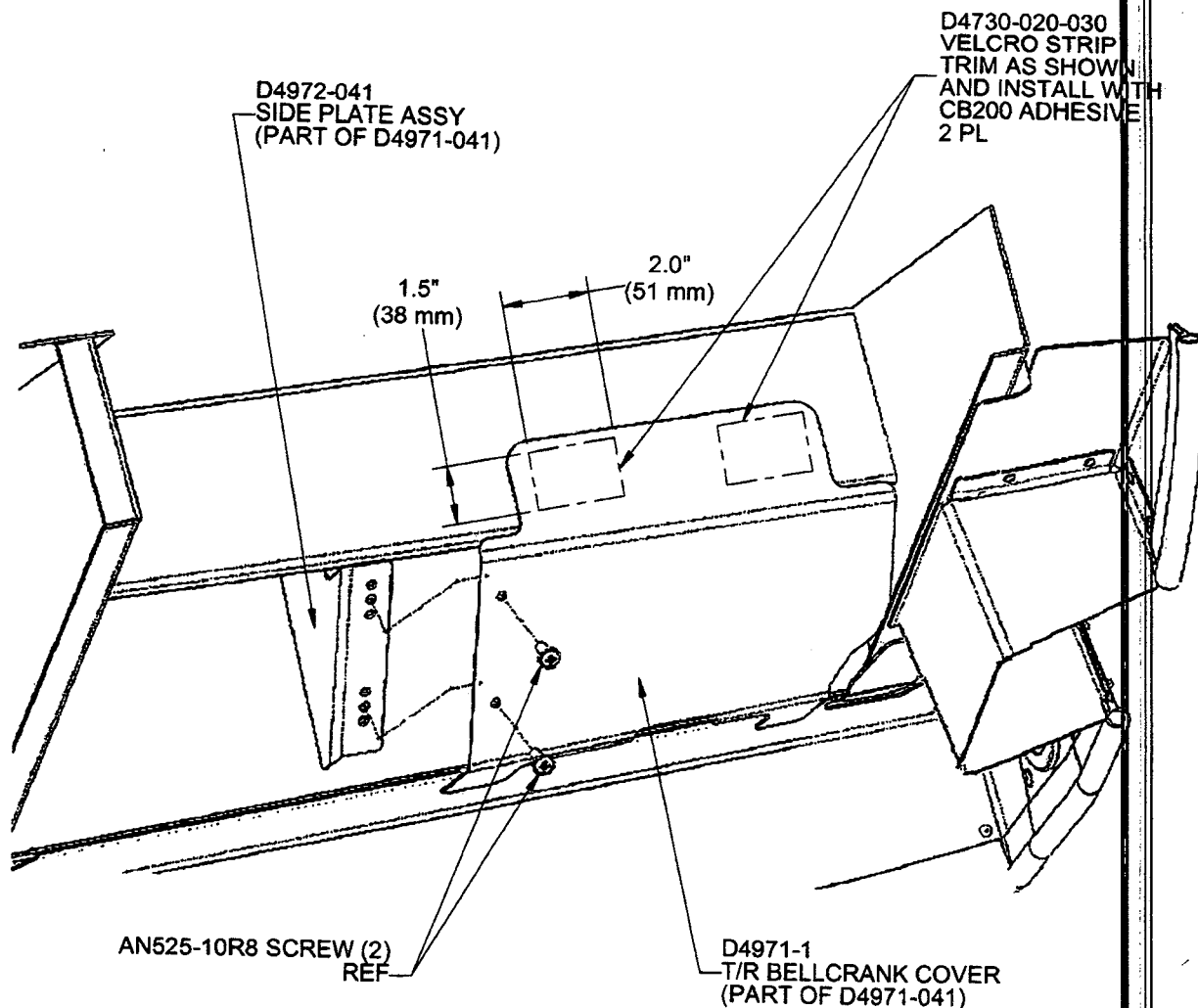


Figure 12b. D4971-041 T/R Bellcrank Cover Assy Installation (-143/-145)

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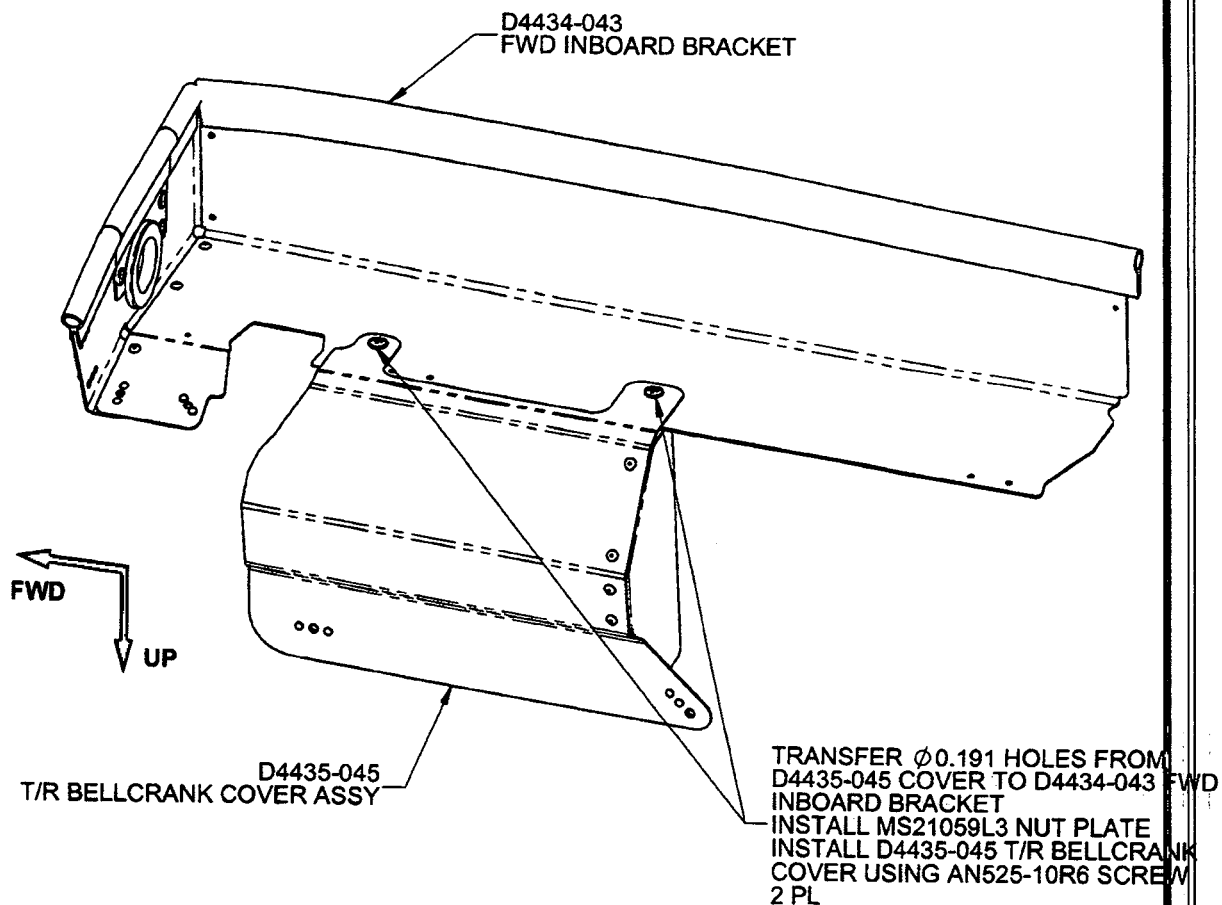


Figure 13a. D4435-045 Cover Installation (-141 ONLY)

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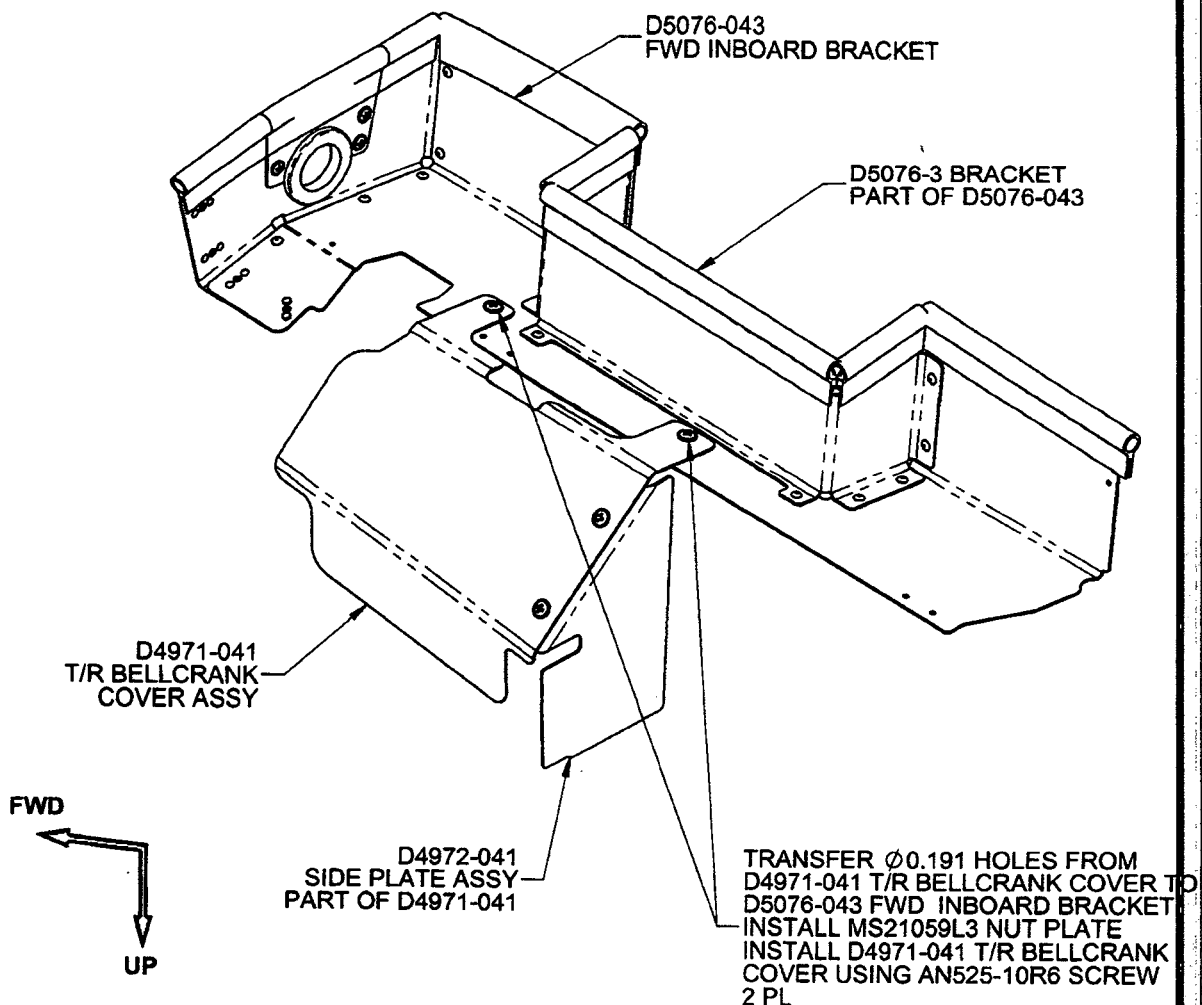


Figure 13c. D4971-041 INSTALLATION INTO D5076-043 (-145 ONLY)

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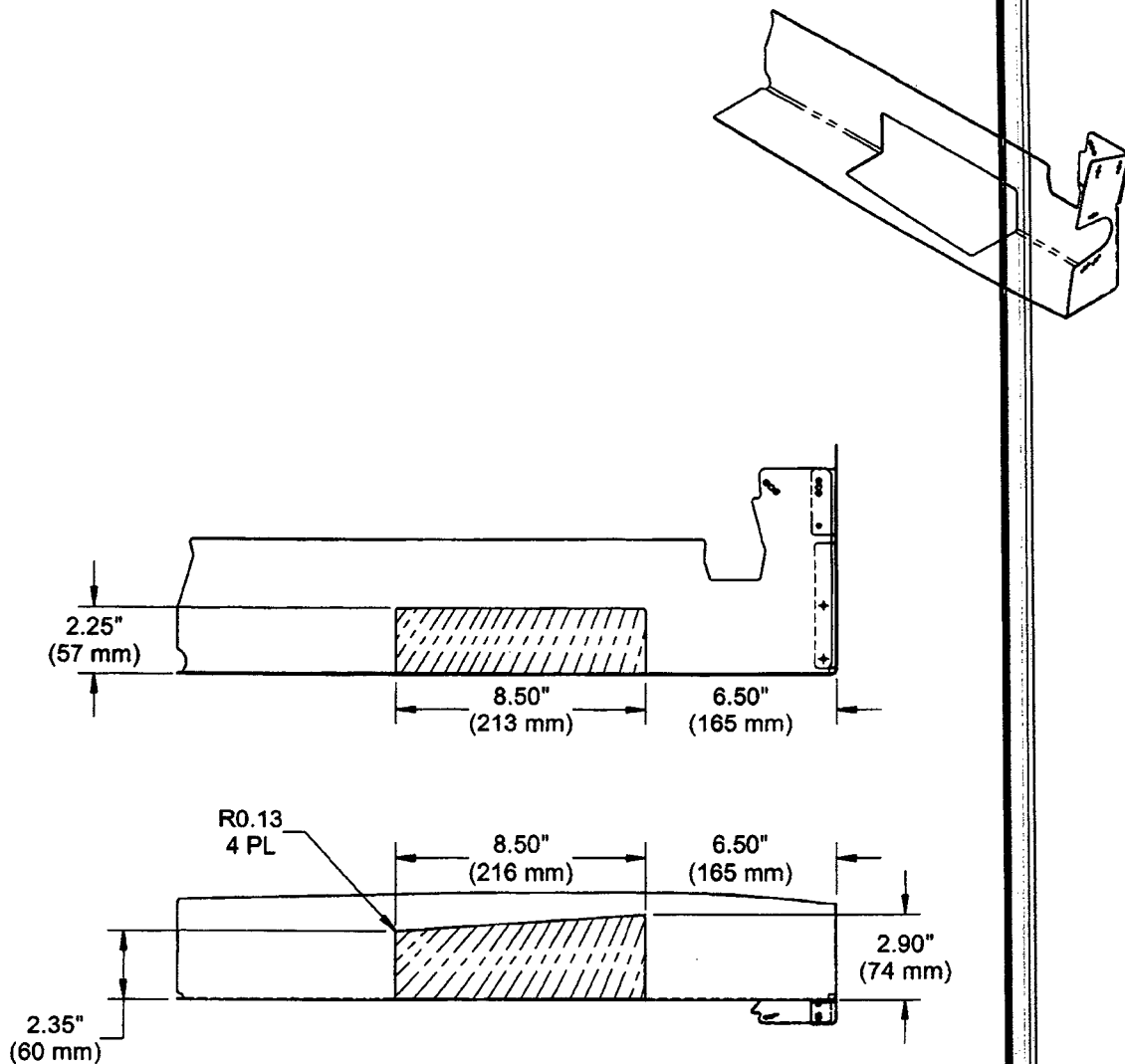


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

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Work Order ID 135464

Wednesday, August 12, 2015 4:29:43 PM

135464

Page 1

Item ID: D350-567-141

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Window Close Out

Start Date: 7/31/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/12/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLS Date: AUG 14 2015 Tooling:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9590	F	JA							
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-141 CHG004								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLS AUG 18 2015

2

2 JA AUG 17 2015

REFERENCE ONLY

DAS
02
9-88

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

△ F

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

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